








Work Order ID 68733

Wednesday, April 20, 2011 11:16:29 AM

Page 1

Item ID:	D3023-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Back Panel					
Start Date:	4/20/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	4/25/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-04-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3023	Rev A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3023								
2024.032	Dwg Rev: 								
	Prog Rev: 								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

1811-4-24

①

1811-4-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68733

Wednesday, April 20, 2011 11:16:29 AM

Page 2

Item ID: D3023-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Subtotal

Quality Control

(X)

130

NC BRAKE

0.00



Brake NC

Memo

0.00

8/11/25

Brake NC

1-Bend as per Dwg D3023-2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

(1)

BR 11-5-2

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/11/25

Quality Control

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68733

Wednesday, April 20, 2011 11:16:29 AM



Page 3

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M-h 11/05/02

1X

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 11/05/02

Memo

0.00

Powder Coating

START TIME: 1:00

OVEN TEMPERATURE:

328 FINISH TIME: 1:30

1 BL 11-5-2

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/05/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68733

Wednesday, April 20, 2011 11:16:29 AM

Page 4

Item ID: D3023-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00

Required Date: 4/25/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: *6-A**W/O 68622*

0.00

Memo

0.00

EP 11/05/03 @

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/5/3 @**11/05-3*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

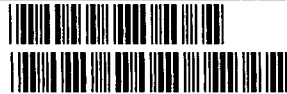
Wednesday, April 20, 2011 11:16:36 AM

Page 1

Work Order ID: 68733

Parent Item: D3023-1

Parent Item Name: Back Panel



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032		Purchased	No			100	sf	55.5000	2.8777	3.029158			
--------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



2024-T3 .032 sheet



HB11-4-21

Location

Loc Qty

Loc Code

MAT22

55.5

111699

0.5

113189

55

113189

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48733
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.127	*		V HSc2	
Ø0.191	+0.005/-0.001	.191	*		V	
1.660	+/-0.010	1.661	*		V	
0.375	+/-0.010	.374	*		V	
1.340	+/-0.010	1.338	*		V	
2.375	+/-0.010	2.377	*		V	
0.375	+/-0.010	.373	*		V	
25.28	+/-0.030	25.28	*		T Bcl	
27.03	+/-0.030	27.03	*		T	
28.10	+/-0.030	28.10	*		T	
1.30	+/-0.030	1.297	*		V	
2.375	+/-0.010	2.375	*		V	
8.711	+/-0.010	8.711	*		T	
5.597	+/-0.010	5.597	*		T	
8.57	+/-0.030	8.57	*		T	
1.970	+/-0.010	1.970	*		V	
7.42	+/-0.030	7.42	*		T	
10.92	+/-0.030	10.92	*		T	
14.75	+/-0.030	14.75	*		T	

Measured by:	RB
Date:	11-4-21

Audited by:	J
Date:	11/04/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

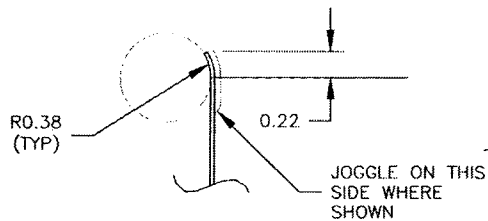
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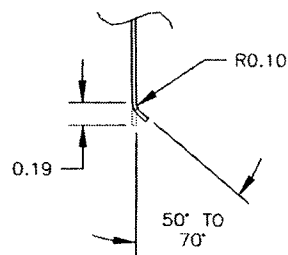
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48733

11-04-20

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

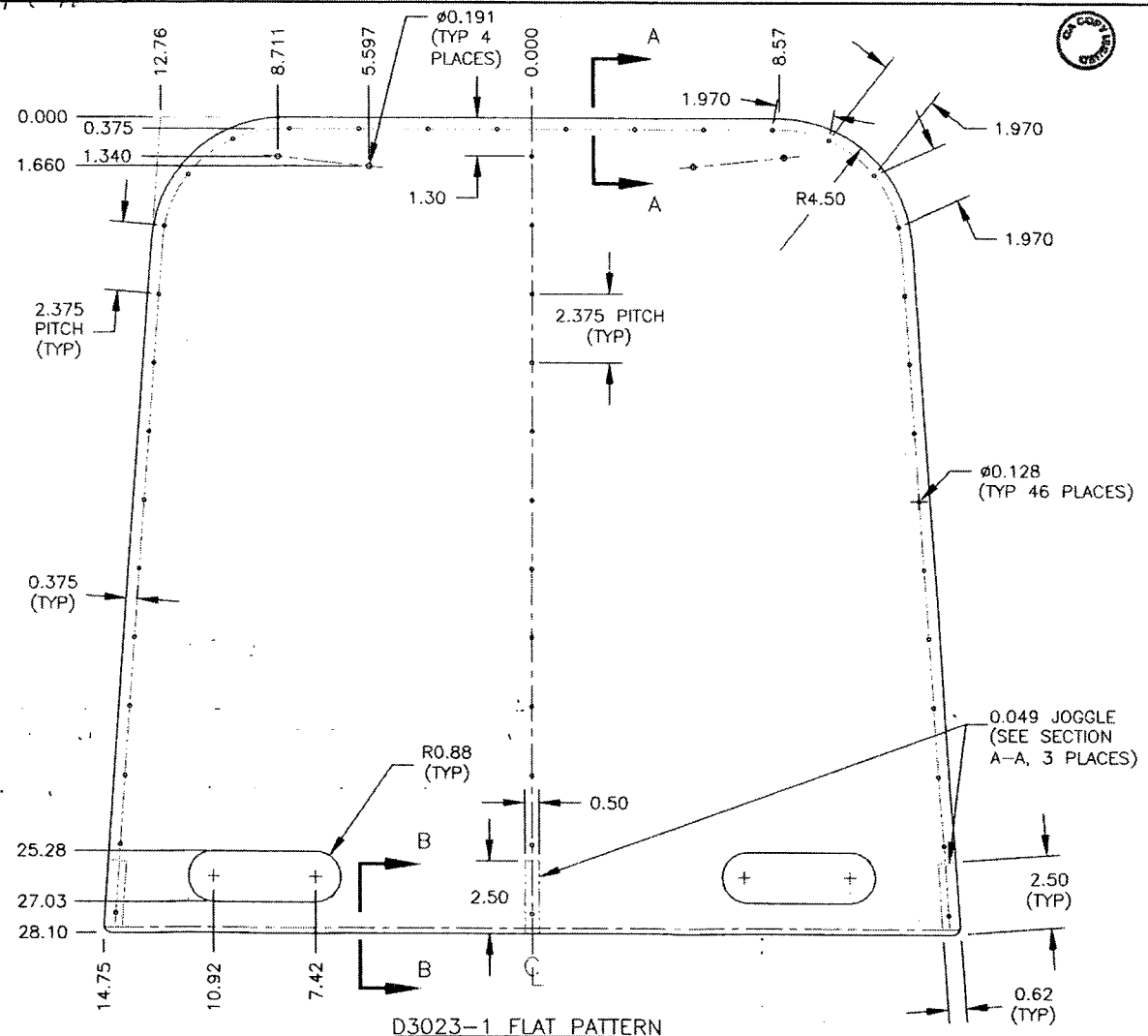


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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